

# Work Order ID 55954

February 8, 2010 10:37:07 AM

Page 1

Item ID: D3121-045

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 2/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Handwritten signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

140



Small Fab

Small Fab

Small Fab

0.00

0.00

Memo

Pull from stock:

1 x D3121-145 B21167

cut to D3121-045

remove old style bearings and re-assemble

Assemble D3121-045 as per Dwg D3121 Identify as D3121-045



*Handwritten: 7 m-l*

*Handwritten: 10/01/08*

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

*Handwritten: 5 10/02/08*



**Work Order ID 55954**

February 8, 2010 10:37:07 AM

Page 2

Item ID: D3121-045

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 2/08/10 Start Qty: 1.00

Required Date: 2/08/10 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 235

0.00

Packaging

Memo

0.00

Packaging

restock using new B/N

10-2-8 SJ

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/08 JF

W 10-02-08

# Picklist Print

February 8, 2010 10:37:06 AM

Page 1

Work Order ID: 55954



Parent Item: D3121-045



Parent Item Name: Bracket Assembly

Start Date: 2/08/10

Required Date: 2/08/10

Comments: IPP B: 02.01.27 Revised Steps 10-11: [KJ/JLM]  
 IPP Rev:C ECN 1060 07-11-12 DD verified by: EC  
 IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3121-21		Manufactured	No			140	Each	37.0000	2.0000			



Bolt



*original screws*  
*W*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

37

46032

5

50096

10

54769

2

54797

20

100

Each

45.0000

2.0000

*2x m-h 10/01/08*

D3121-241

Manufactured No



Bearing Assembly



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

54770

12

Main Warehouse

ST235B

33

55005

33

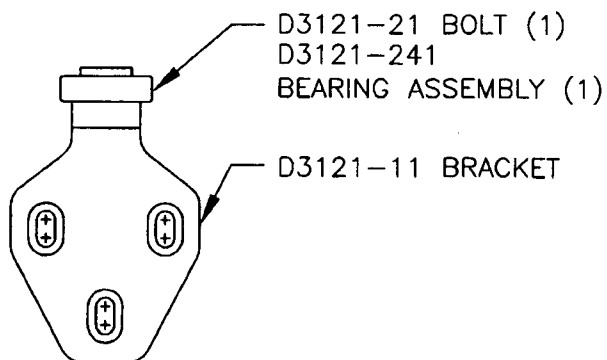
*2x m-h 10/01/08*

*55954*

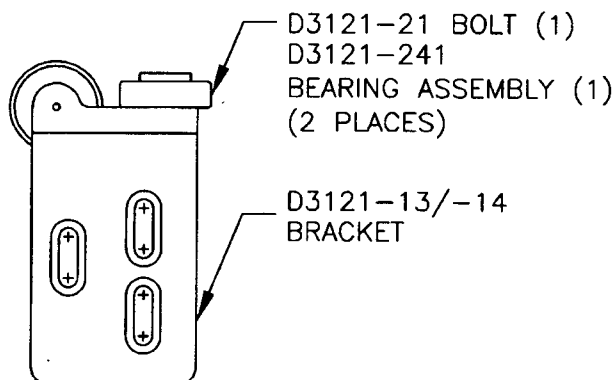
**DART**

DESIGN <i>A</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

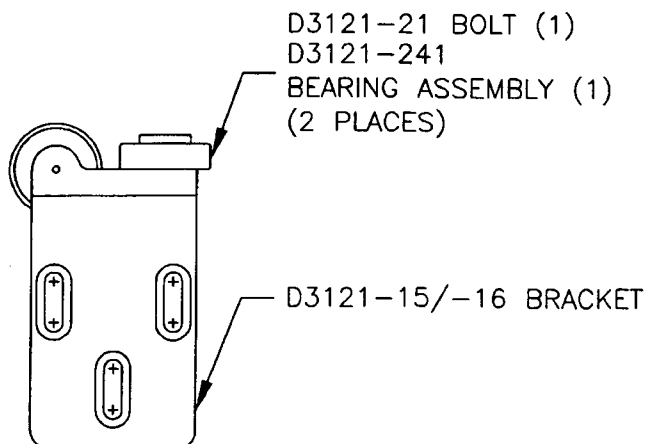
**RELEASED**  
07.11.07



**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

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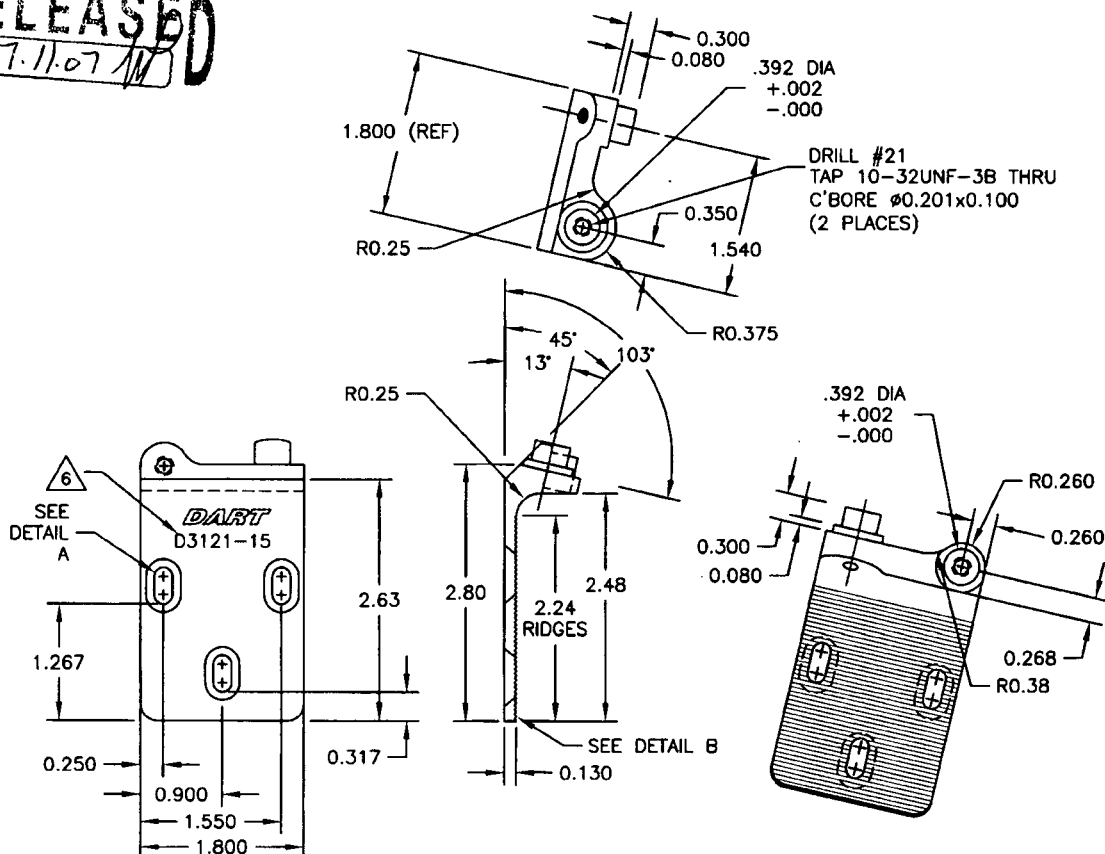
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55954



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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 6 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED  
07.11.07



**D3121-15 BRACKET (SHOWN)**

**D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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